

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015447**Date Inspected:** 11-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Orthotropic Box Girder(OBG)				

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Bay -5

This QA Inspector performed Dimension survey along with Mr.Manunath Math for the Traveler Rails below mentioned all the details. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

22 TR2- 002, 22TR3-003, 22 TR4-004, 22 TR1-001.

1. Thickness at Typical Section
2. Thickness at Sliding Connection
3. Flange width at typical section
4. Flange width at Sliding Connection
5. Web to Flange offset

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6. Traveler Rails length
7. Traveler Rail longitudinal Elevation
8. Traveler Rail Sweep
9. Depth Typical Section
10. Depth Sliding Connection

Segment # 7BE

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Manjunath Math Joint Survey Inspection for the following.

Flatness measurement for Side Panel to Corner Assembly Longitudinal Weld (Cross Beam Side) from PP 49 to PP 51 Measurement area. Those locations after rectification ZPMC offer, Re-inspection after the Heat Straightening found satisfaction all these details noted and forwarded to team leader for further action.

Panel Point from PP 49 towards PP 51

250mm to 1950mm two point of contact measurement deformation 2.5~ 3mm max.

Panel Point from PP 50 towards PP 51

530mm to 1600mm two point of contact measurement deformation 1~ 3mm max.

3400mm to 5000mm two point of contact measurement deformation 2 ~ 3mm max.

Segment # 7BE

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Manjunath Math Joint Survey Inspection for the following.

Flatness measurement for Side Panel to Corner Assembly DP to DP (Cross Beam Side) from Panel Point 50 Measurement area. Those locations after rectification ZPMC offer, Re-inspection after the Heat Straightening found satisfaction all these details noted and forwarded to team leader for further action.

Measurement from Panel Point 50

1235mm two point of contact measurement deformation 2 ~ 3mm max.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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